

Date: Wednesday, 06/09/2006 11:05:17 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : GPS BOTTOM MOUNTING
<b>Job Number</b> : 28422	
<b>Estimate Number</b> : 12518	
<b>P.O. Number</b> :	<b>Part Number</b> : D35301
<b>This Issue</b> : 06/09/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : UNDER REVIEW <i>EC 06-09-05</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> : <i>EC</i>	<b>Due Date</b> : 13/09/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A New Issue 06-08.30 EC	

## Additional Product

PRELIMINARY ISSUE

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M6061T6S040	6061-T6 .040 Sheet
-----	-------------	--------------------



**Comment:** Qty.: 0.4812 sf(s)/Unit Total : 0.9624 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *119380*

*MM 06 09 06*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET

1-Cut as per Dwg P3530

Dwg Rev: *Pre*

Prog Rev: *Pre*

*MM 06 09 06*

*(2)*

2-Deburr if necessary

*MM 06 09 06*

*(2)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*MM 06 09 06*

*(2)*

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

*EC 06-09-06*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*MM 06-09-07*

*(2)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:17 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS BOTTOM MOUNTING

Job Number: 28422

Part Number: D35301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*a.m 06-09-21*

(2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 06 09 21*

(2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

*See eng. use only*

*EC 06.09.19*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

*07/03/09*

Job Completion



*U 07.03.09*

*Eng Approval*

*CB 07.03.08*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

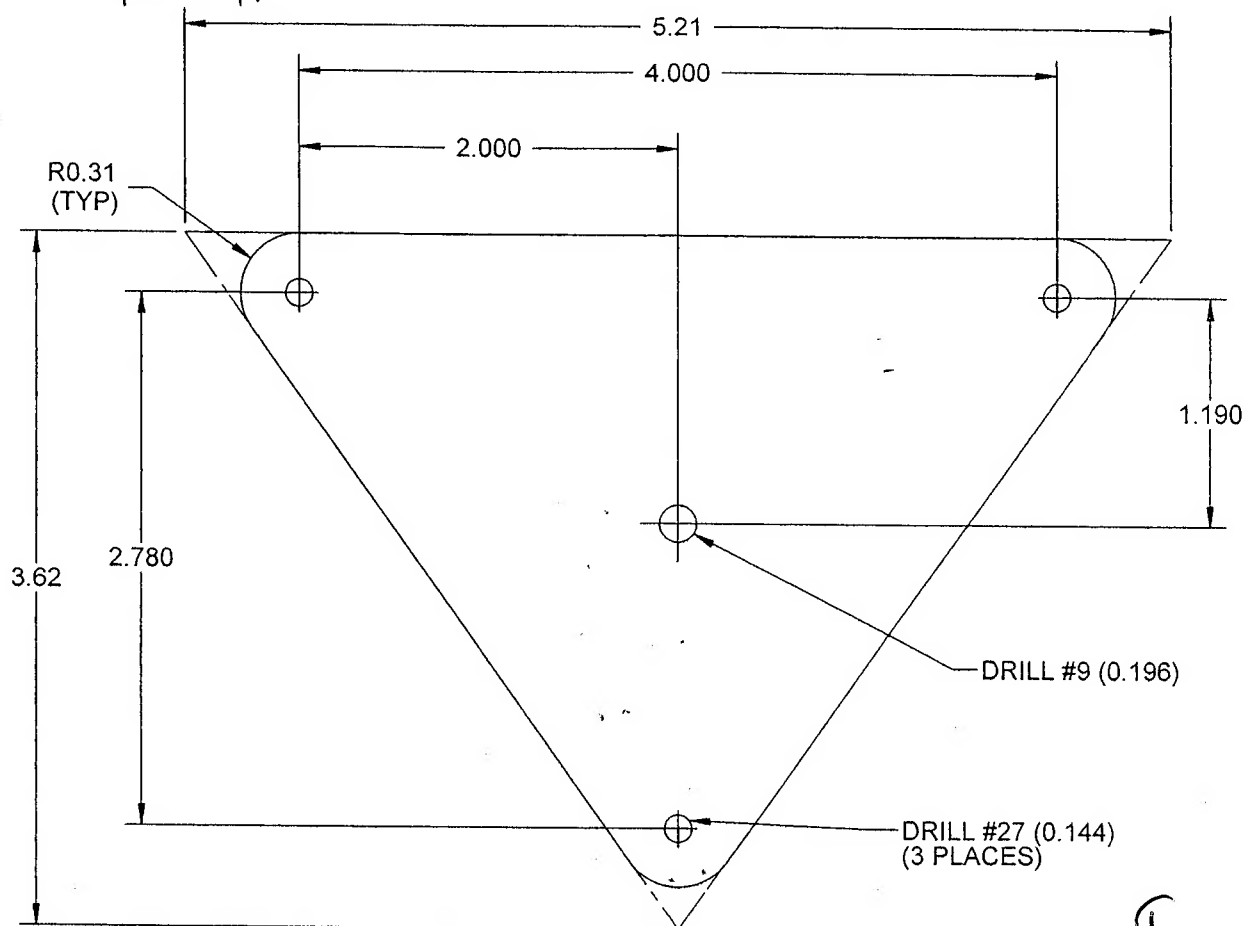
# PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3530	REV. A SHEET 1 OF 2
DATE 06.06.21		TITLE GPS BOTTOM MOUNTING	SCALE 1:1
A	06.06.21	NEW ISSUE	

UNDER REVIEW

06.08.22 cb

prototype



D3530-1F FLAT PATTERN

D3530-1 BASE PLATE

EST  
Powe  
Prog-

## NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET  
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

[illegible]

Measured by: <i>MM</i>	Audited by: <i>ER</i>	Prototype Approval: <i>CB</i>
Date: <i>06.09.06</i>	Date: <i>06.09.06</i>	Date: <i>07.03.08</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DOC : V/0080151422

DATUM : 2005-04-18

PROD. REF. : 0000175932/001

NRBST : 58848/01

PAGINA : 1/ 4



KEURINGSRAPPORT

KLANT : COPPER AND BRASS SALES  
CORPORATE SERVICES DIVISION  
SOUTHFIELD, MI USA

Corus Aluminium N.V.  
A. Stodetlaan 87, 2570 Duffel - Belgium  
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)  
ONS ORDERNUMMER : 58848/01  
DOCUMENT NUMBER : V/0080151422

SPECIFICATIES: ALU SHEETS (STENC-) AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04  
AFMETINGEN : 144" X 48" X 0,04"  
ARTIKEL NR.:

ROL- NUMMER	GEUT- NUMMER	CHEMISCHE ANALYSE (%)							
		MIN	SI	FE	CU	MN	MG	CR	TI
		MAX	0,40		0,15		0,8	0,04	
			0,8	0,7	0,40	0,15	1,2	0,35	0,15
001	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,25
002	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,01
								0,02	0,01

ANDERE : ELK  
TOTAAL :

MIN 0,05 MAX  
MIN 0,15 MAX

TEST- NUMMER	MIN MAX	RM KSI	RP02 KSI	A %
		42	35	10
001	/A	47	39	16
001	/M	47	39	15
001	/V	47	39	16
002	/A	47	39	16
002	/M	48	40	16
002	/V	48	39	16

MECHANISCHE EIGENSCHAPPEN  
1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI  
/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM

COPPER AND BRASS SALES

SOLD TO: C &amp; B

DATE: 12/16 QTY. 20

CUSTOMER PO: 0000604

SHIPPER NO: 4V3128

BY: 8

Corus Aluminium Rolled Products - Corus Aluminium Extrusions